



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3488-3
Job Sheet 187882



Part No: D3488-3

Job Qty: 10 pcs

Part Name: Blade Fitting, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/19/18

Job Tracking No:

Due Date: 1/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DSK101 REV.D / D3488 REV.C IPP REV:A 18.11.09 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	10 pcs		1/4/19	0.00	8.79	Doosan - 1		
110	QC 2	10 pcs		1/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S148053



Part: D3488-3

Job No: 187882

Serial No/Batch: S148053

Revision: D/C

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/25/19

120 HAAS 4 Axis - B4B	10 pcs	1/4/19	0.11 6.86	QC 2 - 8	
				HAAS - 1 - B4B	
				HAAS - 2 - B4B	
				HAAS - 3 - B4B	SBL 19/01/30
				HAAS - 4 - B4B	
130 QC 2	10 pcs	1/4/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 38	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	SBL 19/01/30
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
140 QC 8	10 pcs	1/4/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
150 Handfinish - 1-1 Chemical-B4B	10 pcs	1/4/19	0.00 0.30	QC 8 - 1 (A)	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	

				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.P 19/2/2
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 Powdercoat - 1 White GI(A)- B4B	10 pcs	1/4/19	0.00 0.35	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	BEB 19-02-07.
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
170 QC 3	10 pcs	1/4/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	11 19-2-8
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
200 Packaging 3-1 - Stock - B4B	10 pcs	1/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	PP-661 19-2-8
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	10 pcs	1/4/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-88 FEB 08 2019
				QC 21 - SA - 70	
Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FC491 Descriptions: 110 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB) 120 - HAAS1-3 (HAAS CNC Vertical Machine) 1-Machine as per Folio FA627 & Dwg D3488 130 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB) 140 - QC8 Machining-2 (QC8- Inspect parts - second check) 150 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1) 160 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 10:00 320° FINISH TIME: 10:30 OVEN TEMPERATURE: 170 - QC3 (QC3- Inspect Part Finish) 200 - Packaging3-1 (Identify as per dwg & Stock Location: LOCATION : FP001 210 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6103-003	Round Billet, Aluminum	10 pcs (1 ea)	100-Doosan - 1	S/A 7085 X10	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	D6103-003	10	33	0	
Part Specifications					
Specifications could not be found.					



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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/4/19	0.00	0.00	Start Up Machining-2		
100	Doosan	10 pcs		1/4/19	0.00	8.79	Doosan		
110	QC	10 pcs		1/4/19	0.00	0.00	QC2 Machining-2		
120	CNC Vertical Machining	10 pcs		1/4/19	0.11	6.86	HAAS1-3		
130	QC	10 pcs		1/4/19	0.00	0.00	QC2 Machining-2		
140	QC	10 pcs		1/4/19	0.00	0.00	QC8 Machining-2		
150	HandFinish	10 pcs		1/4/19	0.00	0.30	HandFinish1		
160	Powdercoat	10 pcs		1/4/19	0.00	0.35	Powdercoat1		
170	QC	10 pcs		1/4/19	0.00	0.00	QC3		
200	Packaging	10 pcs		1/4/19	0.00	0.00	Packaging3-1		
210	QC21-SA	10 Ea		1/4/19	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FC491

Descriptions: 120 - 1-Machine as per Folio FA627 & Dwg D3488

160 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

200 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003	Round Billet, Aluminum	10 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6103-003	10	22	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042) Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details: _____			

DART AEROSPACE LTD	Work Order:	187882
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2	Part Number:	D3488-1-3
Inspection Dwg: D3488 / DSK101 Rev: C / D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.151				
Ø2.780	+/-0.005	2.779				
Ø3.125	+/-0.010	3.124				
Ø3.346	+/-0.010	3.347				
0.125 x 45°	+/-0.010 x +/-0.1°	1.20 x 45°				
8.000	+0.030/-0.000	8.010				inside Hole
9.250	+/-0.010	9.251				
0.188	+/-0.010	0.188				
R0.032	+/-0.010	R0.032				
R0.062	+/-0.010	R0.062				
Ø0.297	+0.005/-0.001	X				
Ø0.430	+/-0.010					
0.100	+/-0.010					
0.200	+/-0.010	0.198				
2.620	+/-0.010	2.618				
3.500	+/-0.010	X				
1.005	+/-0.010					
Ø0.484	+0.005/-0.001	0.486				
1.180	+/-0.010	1.180				
3.150	+/-0.010	3.150				
3.070	+/-0.010	3.066				
R0.063	+/-0.010	R0.063				

DART AEROSPACE LTD	Work Order: 187882
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2	Part Number: D3488-3
Inspection Dwg: D3488 / DSK101 Rev: C / D	Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	.508	✓		P.G.	
0.750	+/-0.010	.750	✓		Vern	
1.500	+/-0.010	1.500	✓		Vern	
11.18	+/-0.030	11.180	✓		H.G.	
R0.062	+/-0.010	.062	✓		R.G.	
0.125	+/-0.010	.127	✓		Vern.	
0.590	+/-0.010	.583	✓		H.G.	
0.793	+/-0.010	.796	✓		Mech.	
1.351	+/-0.010	1.350	✓		H.G.	
1.317	+/-0.010	1.317	✓		Vern.	
1.802	+/-0.010	1.802	✓		H.G.	

Measured by: SBC	Audited by: [Signature]	Prototype Approval:	N/A
Date: 19/01/25	Date: 19/02/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-041	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	
D	18.11.21	Dimension 0.125 changed to 0.200	MG	[Signature]